



Dart Aerospace Ltd.
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D2594-1**Job Sheet 183553****Part No:** D2594-1**Job Qty:** 71 ea**Part Name:** Plug**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** High**Job Created:** 9/20/18**Job Tracking No:****Due Date:** 9/21/18**Created By:** Jason Leroux**Type:** SOLD**Description:****Note:** DWG REV C IPP D 02.08.22 Make in Cobra KJ IPP E 06.12.11 ecn 836 EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	71 Ea	9/21/18	9/21/18	0.00	0.00	Start Up Machining		
100	Hardinge	71 pcs	9/21/18	9/21/18	0.01	2.04	Hardinge		
110	QC	71 pcs	9/21/18	9/21/18	0.00	0.00	QC2		
120	QC	71 pcs	9/21/18	9/21/18	0.00	0.00	QC8		
130	HandFinish	71 pcs	9/21/18	9/21/18	0.00	0.16	HandFinish1		
135	Powdercoat	71 pcs	9/21/18	9/21/18	0.00	0.11	Powdercoat1		
150	QC	71 pcs	9/21/18	9/21/18	0.00	0.00	QC3		
160	Packaging	71 pcs	9/21/18	9/21/18	0.00	0.00	Packaging3 FP-001		
170	QC21-SA	71 Ea	9/21/18	9/21/18	0.00	0.00	QC21		

Part Op 100 - 1-Make as per Dwg D2594-1 and Folio FA262.

Descriptions: 135 - START TIME:

160 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.625	6061-T6 Round Bar .625"	3.6991 (-0521 ea)	90-Start up Operation	S061/30

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.625	4	123	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	0.060inches $\pm$ 0.005	0.065 0.055	<i>1.616</i>	<i>.059</i>
2	Plug	0.500inches $\pm$ 0.010	0.510 0.490	<i>.503</i>	
3	Plug	0.625inches $\pm$ 0.010	0.635 0.615	<i>.625</i>	
4	Plug	0.430inches + 0.000 - 0.002	0.430 0.428	<i>.4285</i>	
5	Plug	0.090inches + 0.000 - 0.002	0.090 0.088	<i>.09</i>	
6	Plug	0.045inches + 0.000 - 0.002	0.045 0.043	<i>.0435</i>	

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Container No: S111819



Part: D2594-1

Job No: 183553

Serial No/Batch: S111819

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/20/18